

Date: Friday, 8/25/2006 11:21:34 AM  
 User: Jim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BEARPAW KIT (13"X16")
<b>Job Number</b> : 28342	
<b>Estimate Number</b> : 10317	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : K10005
<b>This Issue</b> : 8/25/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2671 REV B1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B1
<b>Previous Run</b> : 25288	<b>Material</b> : N/A
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 9/25/2006 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>[Signature]</u> 06-08-25	
<b>Comment</b> : Est Rev: C04.02.17 Blank size changed KJJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile: K10005

D206-559-021

D500-572-021

and create labels per PPP K10005 CHG002

(Bag Bluefiles separately)

KS 06-08-25

2.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 2.9444 sf(s)/Unit Total: 29.4440 sf(s)  
 blank: 13.25" x 16.00" x 1.00" thick (+0.030/-0.000) per DSK086-1  
 Material: Black UHMW 1"  
 (MUHMWB10)  
 Batch: M101254

J.F. 06/09/01 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2671 Identify as D2671

3-Deburr

J.F. 06/09/01 10



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/09/01

10

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 06/09/02

10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.4160 f(s)/Unit Total: 4.1600 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 D2182B050 Rubber Cushion B28042

8.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch ✓ B27581 8mly

✓ 8 D2274 Radius Block

2 D2671(ref only) Bearpaw B28342 ✓ B28344 72mly

9.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 D2438 Clamp B25611 4mly



✓ B27080 20m → sorti 15 août 5 dans l'info

✓ B28345 16



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 D2529 Washer 027876

11.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN4-15A Bolt M19185 8mcp M102039 72mcp

12.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN4-17A Bolt M19471 8mcp  
M101124 72mcp

13.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 16 AN960JD416 Washer M19185 46-144  
M101369 46

14.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 MS21042L4 Nut (or -4) M19085



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 02/18/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 QS200M44S Clamp

1 Paperwork package

7102039 8X  
1102296 14X

PC 4/9/25 (10)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W PS 06/10/06 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPk10005

Location: \_\_\_\_\_

ReVC 06/10/06 (10)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/06 (10)

Job Completion



W 06/10/06



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	28342
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2671
<b>Inspection Dwg:</b> D2671	<b>Rev:</b> B1	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053" x 45°	✓			
B	5.500	+/-0.030	5.499"	✓			
C	0.200	+/-0.030	.203"	✓			
D	R0.250	+/-0.030	R.250"	✓			
E	0.625	+/-0.030	.623"	✓			
F	0.250	+/-0.010	.248"	✓			
G	0.950	+0.030/-0.010	.949"	✓			
H	0.25 x 45°	+/-0.030	.232" x 45°	✓			
I	0.375	+/-0.010	.375"	✓			
J'	12.750	+/-0.030	12.754"	✓			
K	Ø0.260	+0.005/-0.000	Ø.259"	✓			
L	Ø0.93	+/-0.030	Ø.929"	✓			
M	0.30	+0.030/-0.000	.315"	✓			
N	4.250	+/-0.030	4.242"	✓			
O	0.375	+/-0.030	.380"	✓			
P	2.000	+/-0.030	2.025"	✓			
Q	4.250	+/-0.010		✓			
R	9.000	+/-0.010		✓			
S	15.750	+/-0.030	15.757"	✓			

<b>Measured by:</b>	J.F
<b>Date:</b>	06/08/31

<b>Audited by:</b>	J.G
<b>Date:</b>	06/08/31

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	



B1 02.12.17 |  $\phi 0.93$  WAS  $\phi 0.75$  ~~14~~

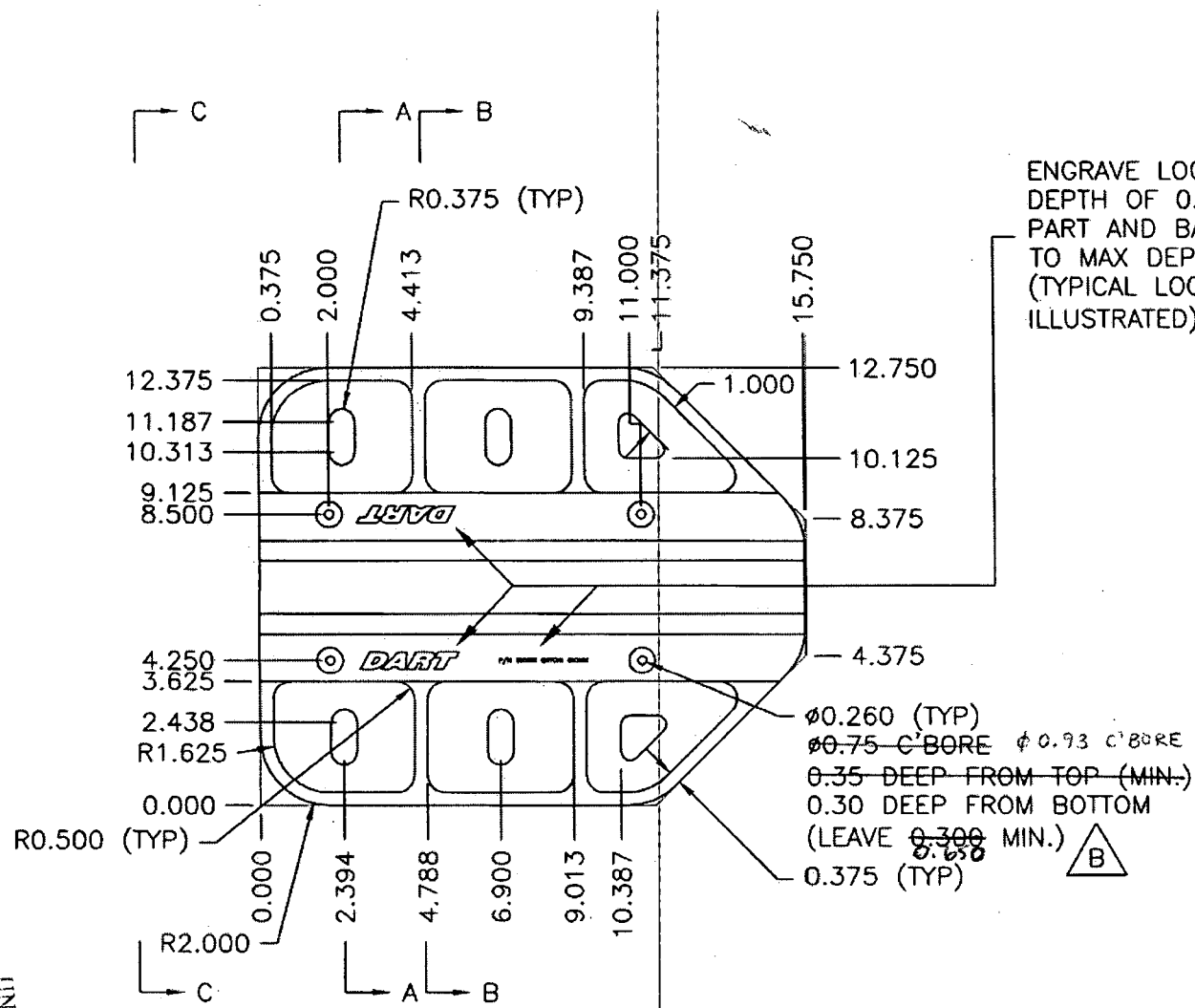


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2671	REV. B
DATE 98.05.19		TITLE BEARPAW	SHEET 1 OF 2
A	97.04.08	NEW ISSUE	SCALE 1:5
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

**RELEASED**  
98.06.17 KE

EFFECTIVE	DEOS
9/43	

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

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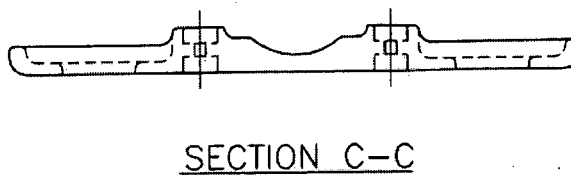
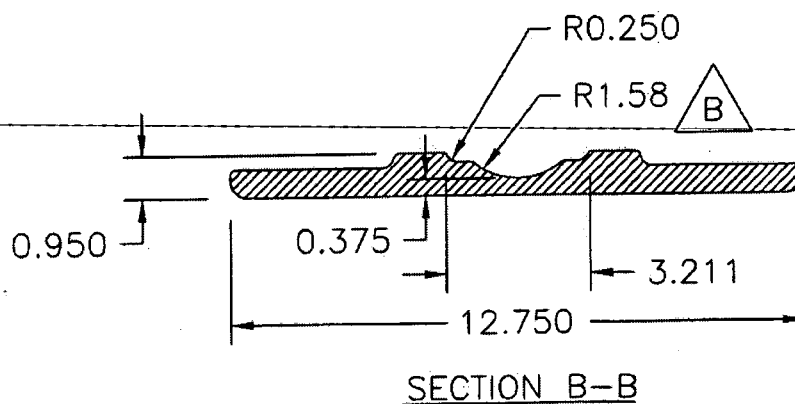
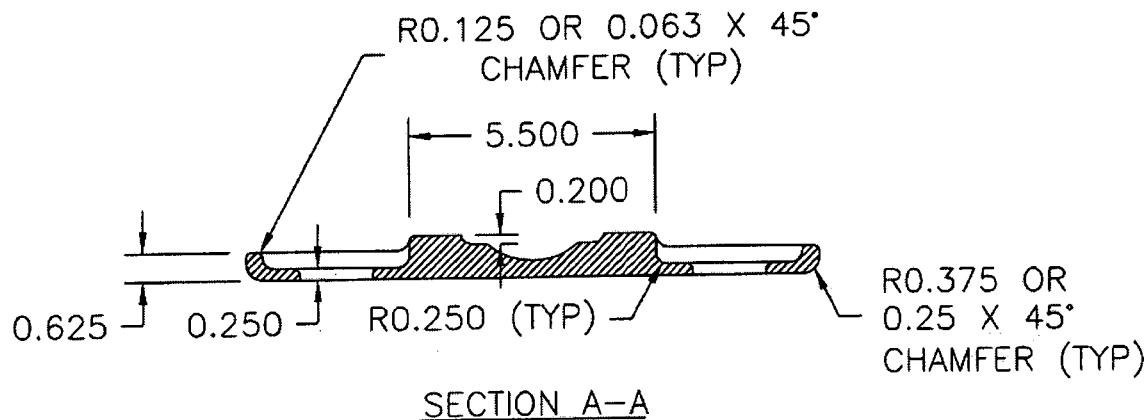
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CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D2671	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE



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